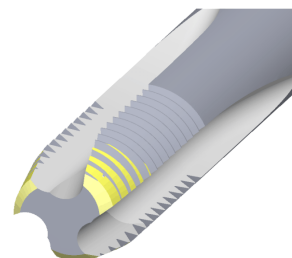
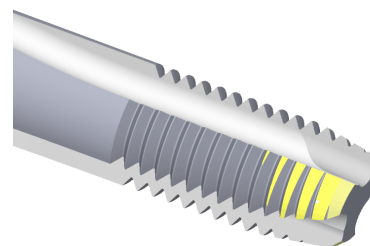

















Spiral Pointed Tap M6 Z3

A10-020

The manufacturing cycle includes the loading and dressing cycle for conventional wheels for flute and thread grinding. After further research in wheel technology the cycle time could be reduced.



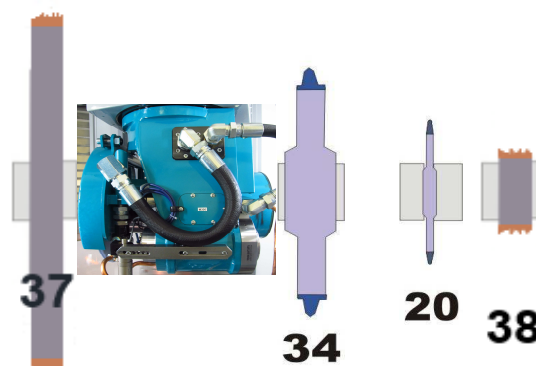
1. Cycletime for Production

Tool specifications								
M6, flutelength 20.3, Helix 0°								
Material HSSE								
Operations								
Loading								
Feed [mm/Min]		1400	60	12000	12000	12000	100	100
Power [kW]		6	6	4	4	4	1	1
Cutting feed [m/s]		60	60	65	65	65	24	24
Used wheels								
Grinding time [s]	20	21	20	25	18	21	16	32
Total cycle time	2 Min 53							

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø180 DXF A100
 37 Ø400 1A1 A250
 20 Ø125 14EE1 D301
 38 Ø90 DXF D301



3. Machine and Software Requirements

Machines: 6 axes CNC grinders : TAP NGM, dressing unit
 Control: Fanuc 31i B5
 Coolant: Synthetic Oil, pressure 9 bar
 Software: Quinto 5.4.6

responsible engineer:

FFR,22.01.15

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland
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